ASAP ship March 21

Work Order ID 114118

114118

March-04-14 12:50:16 PM

Item ID: D4073-1 D4073-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: B114118 **Stop** *NS2*

Item Name: Door Hinge

Start Date: 3/04/14 **Start Qty:** 30.00 *30* **Cust Item ID:**

Required Date: 3/18/14 **Req'd Qty:** 30.00 *30* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 14-03-04 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4073 / B									
100	Cut blanks as per folio	0.00							
100						30	ø		14-03-05
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	cut blank 4.563" long								
105		0.00							
105						30			14-3-7
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg an Folio FA939 Dwg Rev: B Folio Rev: AA								
	Deburr								

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4073-1 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Door Hinge
Start Date: 3/04/14 **Start Qty:** 30.00 *30* **Cust Item ID:**
Required Date: 3/18/14 **Req'd Qty:** 30.00 *30* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC Quality Control	**Memo**	0.00				30	0		SL 14-3-7
120	QC8- Inspect parts - second check	0.00							
120 QC Quality Control	**Memo**	0.00	ok 14/03/07			30	0		
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150 HandFinish Hand Finishing	**Memo**	0.00				30	NB 14-3-11		

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Item ID: D4073-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Door Hinge
Start Date: 3/04/14 **Start Qty:** 30.00 *30*
Required Date: 3/18/14 **Req'd Qty:** 30.00 *30*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum MB8007. Memo	~~0.00~~ START: 2:00 OVEN T: 320° FINISH 2:30				30	✓	14-3-11	DAS 34 9-89
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 DAS 27 9-89 0.00 14/3/12				30			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: STO90 Memo	0.00 0.00				30x	DAS 28 9-89	14-03-12	

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 114118

March-04-14 12:50:16 PM

114118

Item ID: D4073-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Door Hinge

Start Date: 3/04/14 **Start Qty:** 30.00 *30*

Required Date: 3/18/14 **Req'd Qty:** 30.00 *30*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190						MCJ	14-03	-13	
QC	**Memo**	0.00							
Quality Control									

MF 14-3-13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

March-04-14 12:50:19 PM

Work Order ID: 114118 *114118*

Parent Item: D4073-1 *D4073-1*

Parent Item Name: Door Hinge

Start Date: 3/04/14 **Required Date:** 3/18/14

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.250		Purchased	No			100	f	0.0000	0.38	12			

M6061T6B2.000X01.250

~~6061-T6 Bar 2.00 x 1.25~~

6061-T6 Bar 2.00 X 1.500

** 11.625' 14-03-05

M 126726 11.625'

* Not Pulled

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Use-as-is ☐
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AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Other _____

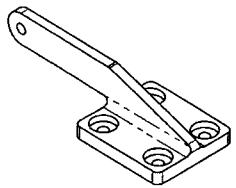
DART AEROSPACE LTD	Work Order:	114118
Description: Door Hinge	Part Number:	D4073-1
Inspection Dwg: D4073 **Rev:** B		Page 1 of 1

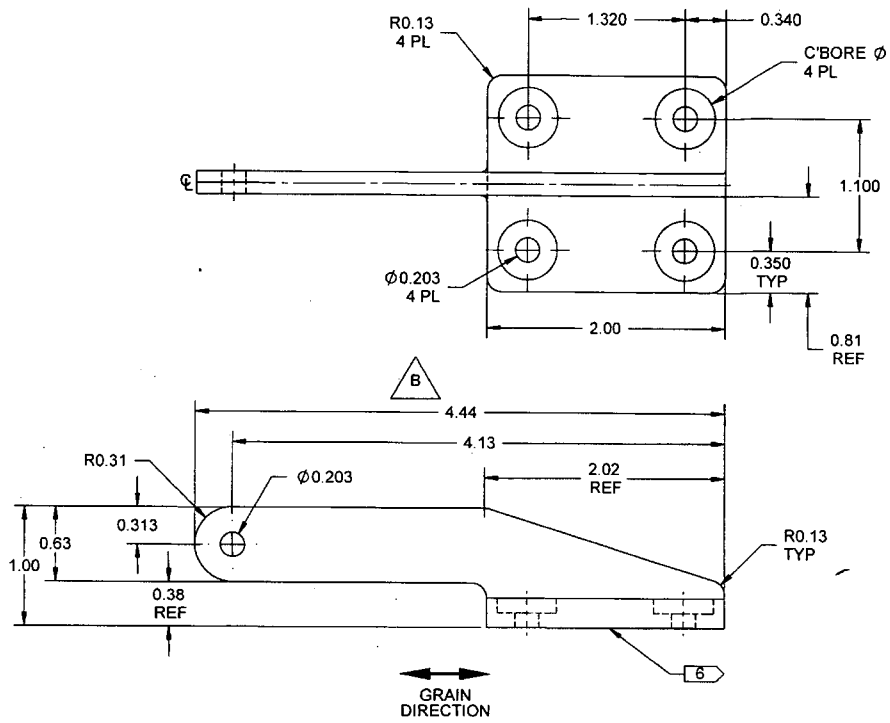
FIRST ARTICLE INSPECTION CHECKLIST

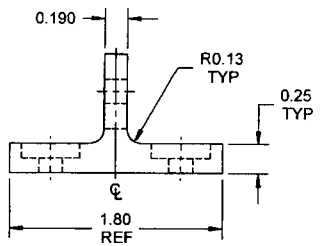
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	.125	✓			
Ø0.203	+0.005/-0.001	.204	✓		Vern	JL-10
2.00	+/-0.030	1.999	✓		″	
0.81	+/-0.030	.805	✓		″	
0.350	+/-0.010	.349	✓		″	
1.100	+/-0.010	1.100	✓		″	
Ø0.500 x 0.125	+/-0.010	.501 x .124	✓		″	
0.340	+/-0.010	.339	✓		″	
1.320	+/-0.010	1.320	✓		″	
4.44	+/-0.030	4.438	✓		″	
4.13	+/-0.030	4.125	✓		″	
R0.31	+/-0.030	.313	✓		✓	
0.313	+/-0.010	.314	✓		✓	
0.63	+/-0.030	.628	✓		✓	
1.00	+/-0.030	1.003	✓		✓	
0.38	+/-0.030	.375	✓		✓	
0.190	+/-0.010	.191	✓		✓	
1.80	+/-0.030	1.799	✓		✓	
0.25	+/-0.030	.251	✓		✓	
R0.13	+/-0.030	.125	✓		✓	

Measured by:	JL	Audited by:	[illegible]	Preliminary Approval:	
Date:	14-3-6	Date:	14/03/07	Date:	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	







114/18 MLS
14-03-04

D4073-1 DOOR HINGE

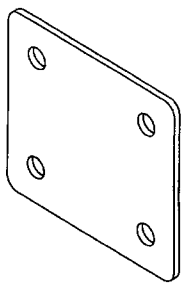
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2011-06-30

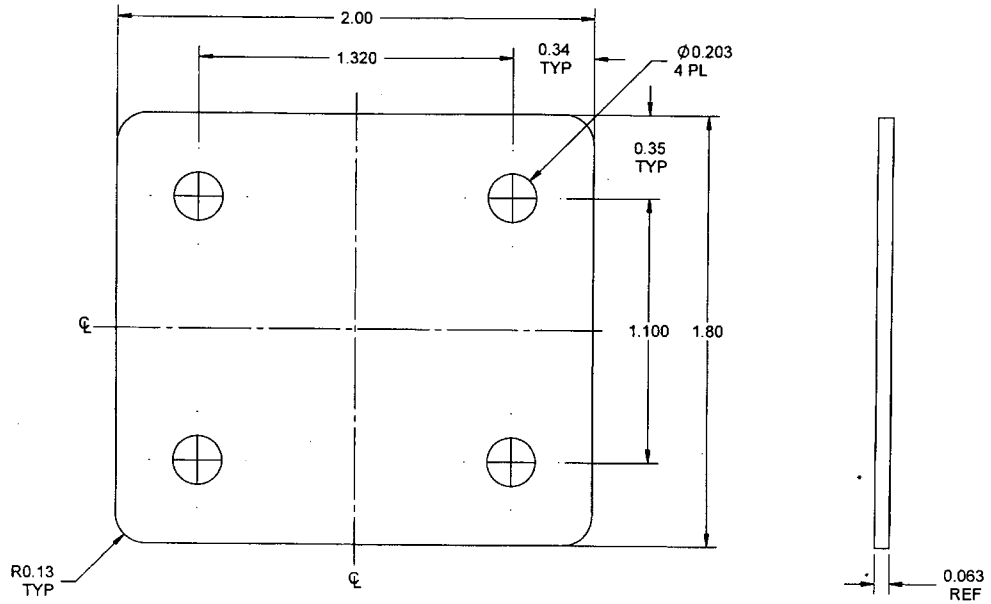
NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.12 lbs

REV.	DESCRIPTION	BY	DATE
B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D4073	REV. B
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE DOOR HINGE	SCALE NTS
DE APPR.			
DATE	11.05.02		

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D4073-3 DOOR HINGE BACKING PLATE

RELEASED
2011 -06- 30

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4073 REV. B
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE DOOR HINGE SCALE NTS
DE APPR.		
DATE	11.05.02	

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